

Date: Wednesday, 9/13/2006 4:30:34 PM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 28527 -1  
Estimate Number : 10675  
P.O. Number : N/A  
This Issue : 9/13/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : LARGE FAB ASSY  
Previous Run : 28164  
Written By :  
Checked & Approved By :  
Comment : EST REV. A 05.11.17 NEW ISSUE EC

Drawing Name : STRUT WELDMENT ASSY  
Part Number : D3443041  
Drawing Number : D3443 REV. B  
Project Number : N/A  
Drawing Revision : B  
Material : N/A  
Due Date : 10/6/2006 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34431 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-1	lug	B28184

PD 06-10-27 (2)

2.0 D34435 Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-5	Tubing	B23186

PD 06-10-27 (2)

3.0 D34531 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-1	Clevis	B28188

PD 06-10-27 (2)

4.0 238805 SS DOWEL PIN 3/4" LONG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-805	SS DOWEL PIN 3/4" LONG	M19080

PD 06-10-27 (2)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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## Process Sheet

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Drawing Name: STRUT WELDMENT ASSY

Job Number: 28527

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3443

AD 06/10/27 (2)

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

AD 06/10/30 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M101575

y/

06/10/31 x2

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/11/06 (2)

9.0

63215K32

Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 63215K32

Spherical Bearing

M101555

SB 06/11/06 2

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotate freely

SB 06/11/06 2

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AD 06/11/06 (2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/11/06 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:30:34 PM  
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## Process Sheet

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Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 28527

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 2  
12/11/07

Job Completion



*Handwritten:* 06.11.07



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

**RELEASED**05.12.09 *H*D3443-1  
LUG (1)D3443-5  
TUBING (1)D3453-1  
CLEVIS (1)

MASK HOLES (TYP)

PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COAT

8.54

INSTALL SPAENAUER  
P/N 238-805 DOWEL PIN  
(TYP)0.10  
(TYP)D3443-7  
TUBING (1)D3443-3  
CLEVIS (1)

9.78

INSTALL SPAENAUER P/N 238-805  
DOWEL PIN

0.10

PARALLEL  
FACES

MASK HOLES

**D3443-041**PARALLEL  
FACES

MASK HOLES

**D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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NO. **28527**

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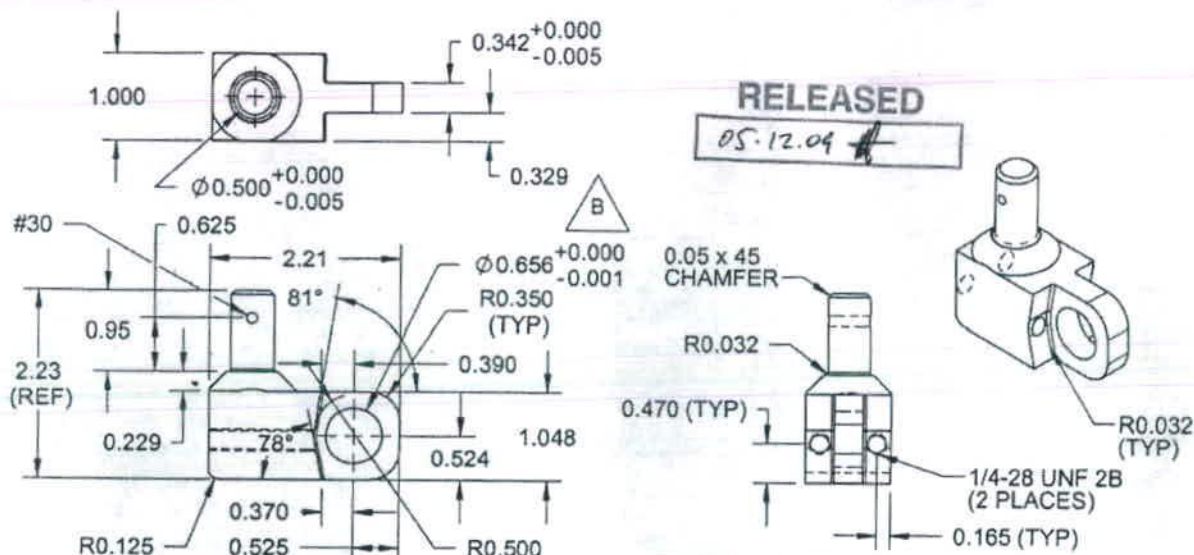
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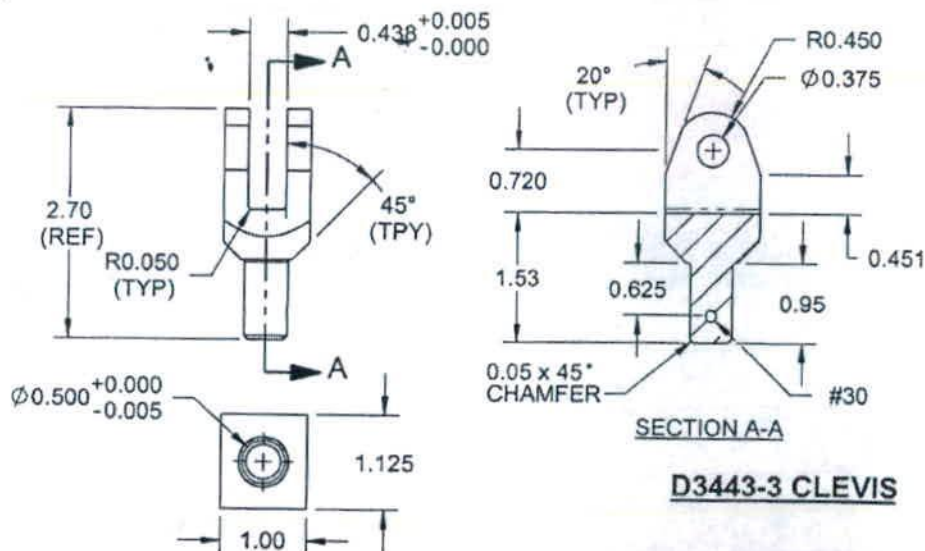


**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 2 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY 1:2</b>		

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

**D3443-3 CLEVIS****D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

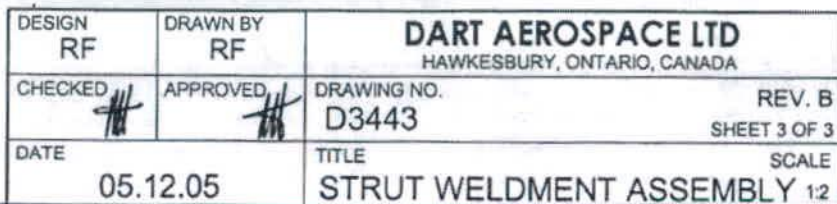
- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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$$\phi 0.210^{+0.005}_{-0.010}$$

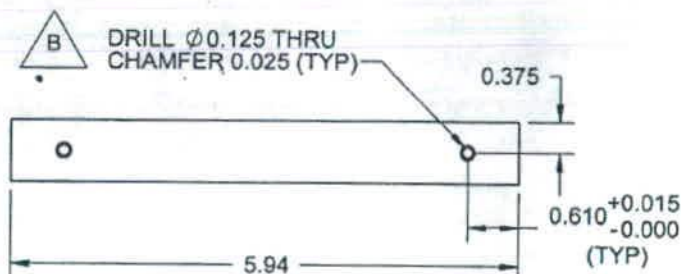

A triangle with the letter 'B' inside it.

D3443-9 PIN

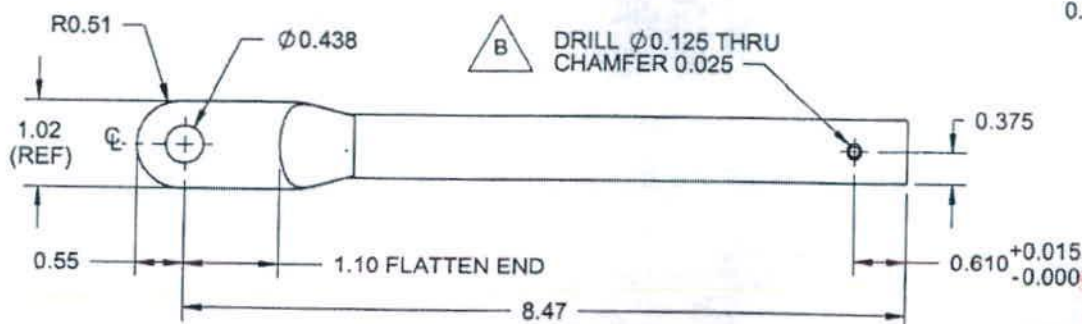
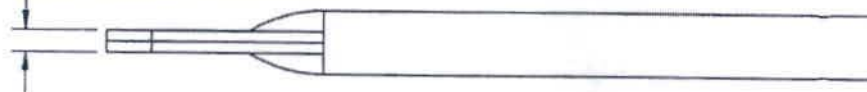
1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.04



Technical drawing of a circular part. The outer diameter is labeled  $\phi 0.750$ . The inner diameter is labeled  $0.120$ . The drawing shows a cross-section of a ring with a central hole.

$$\left[ \begin{array}{c} 0.260^{+0.000} \\ -0.030 \end{array} \right]$$


D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)  
2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

10-0.015  
-0.000

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